

ASAP

Date: Thursday, 7/19/2007 2:25:38 PM  
User: Kim Johnston

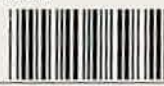

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33660 -1		
Estimate Number	: 12712		
P.O. Number	: N/A	Part Number	: D35371
This Issue	: 7/19/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3537 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33284	Drawing Revision	: C
		Material	: N/A
		Due Date	: 7/31/2007
Written By	:	Qty:	100
Checked & Approved By	: <u>07.07.19</u>	Um:	Each
Comment	: Est Rev: A New Issue 07-02-14 JLM		

Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
		

Comment: Qty.: 0.0788 sf(s)/Unit Total : 6.3000 sf(s)  
M304S16GA .063" 304 SS SHEET  
Batch: M105061

SAD 07/07/20

2.0	WATER JET	FLOW WATER JET
		

Comment: FLOW WATER JET  
1-Cut as per Dwg D3537  
Dwg Rev: C  
Prog Rev: C

2-Deburr if necessary

SAD 07/07/20



100

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/20

100

4.0	QC8	SECOND CHECK
		

Comment: SECOND CHECK

EP 07/07/22

counter 100

5.0	BRAKE NC	NC BRAKE
		

Comment: NC BRAKE  
1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.  
2-Identify as D3537-1

FF. 07-07-31 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng & Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 07/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 7/19/2007 2:25:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33660

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M105258

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

28 07/08/02 (50)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

28 07/08/02 (50)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28 07/08/02 (50)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M104846

M-L 07/08/03

(50)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/07 (50)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

FL 07/08/07 (50)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

28 07/08/02 (50)

Job Completion



28 07-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

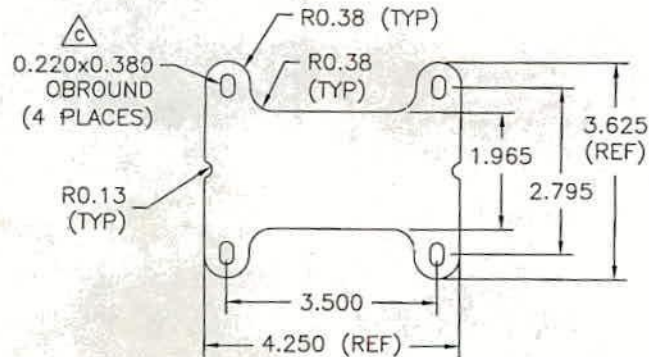
NOTE: Date & initial all entries



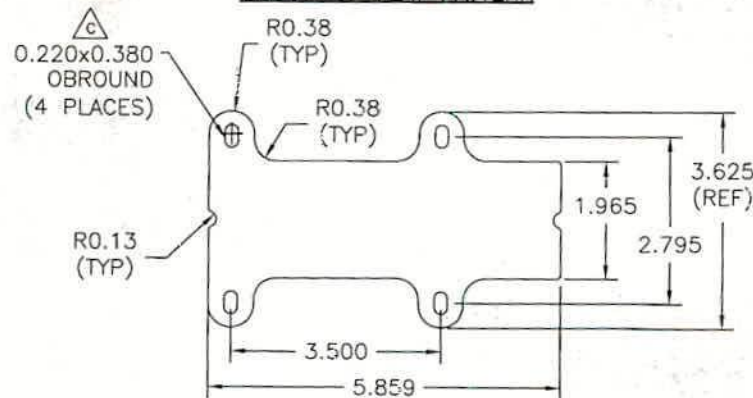




### D3537-1F FLAT PATTERN



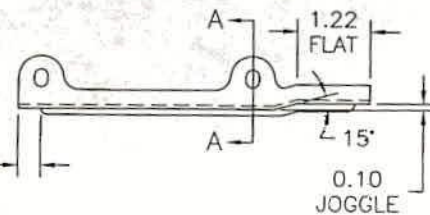
### D3537-3F FLAT PATTERN



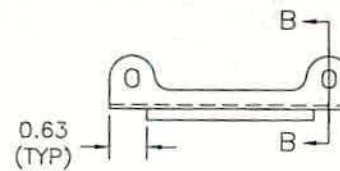
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



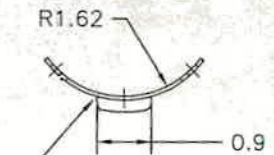
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

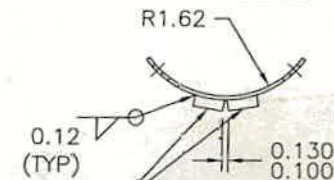


### SECTION A-A



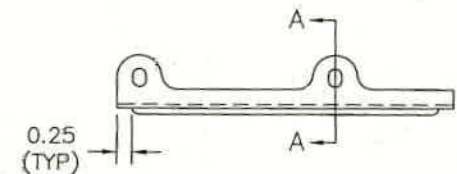
APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

### SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
DART AEROSPACE USA, INC.	PORT HADLOCK, MA	SHEET 1 OF 1
		SCALE 1:2

RELEASED  
07.05.08  
per ECA  
962



